

20

DART AEROSPACE LTD	Work Order:	20701
Description: Hinge Bracket	Part Number:	D2857-2
Drawing: D2857 Rev. A	Qty:	24

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	HF	04.04.13	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)	MJ1706 MJ890 Batch MJ843	04/04/13	24
3	HAAS	Machine per folio D2857-2	ST	04/04/13	24
4	QC	Inspect Level 2	ST	04/04/13	24
5	METAL	Tumble Deburr any rough edges after tumbling	ST	04/04/13	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	ML	04/05/05	24
7	QC	Inspect Level 7	DB	04/05/05	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	ML	04/05/06	24
9	QC	Inspect Level 3	2	04/05/06	24
10	STORES	Identify and stock	CRP	04/05/06	24
11	EXPEDITING	Close W/O Cost / Part: 16.88 SUE 04/05/20 (24)	HF	04.05.11	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

JUN 26 2000

EC

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART**COPIES
GIVEN**

DESIGN **KE** DRAWN BY **JP** DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A

SHEET 1 OF 1

SCALE 1:1

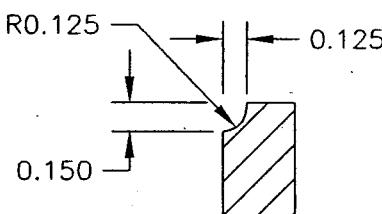
CHECKED	APPROVED	DRAWING NO.
KE	JP	98.12.14 D2857
A	JP	98.12.14 NEW ISSUE

DATE

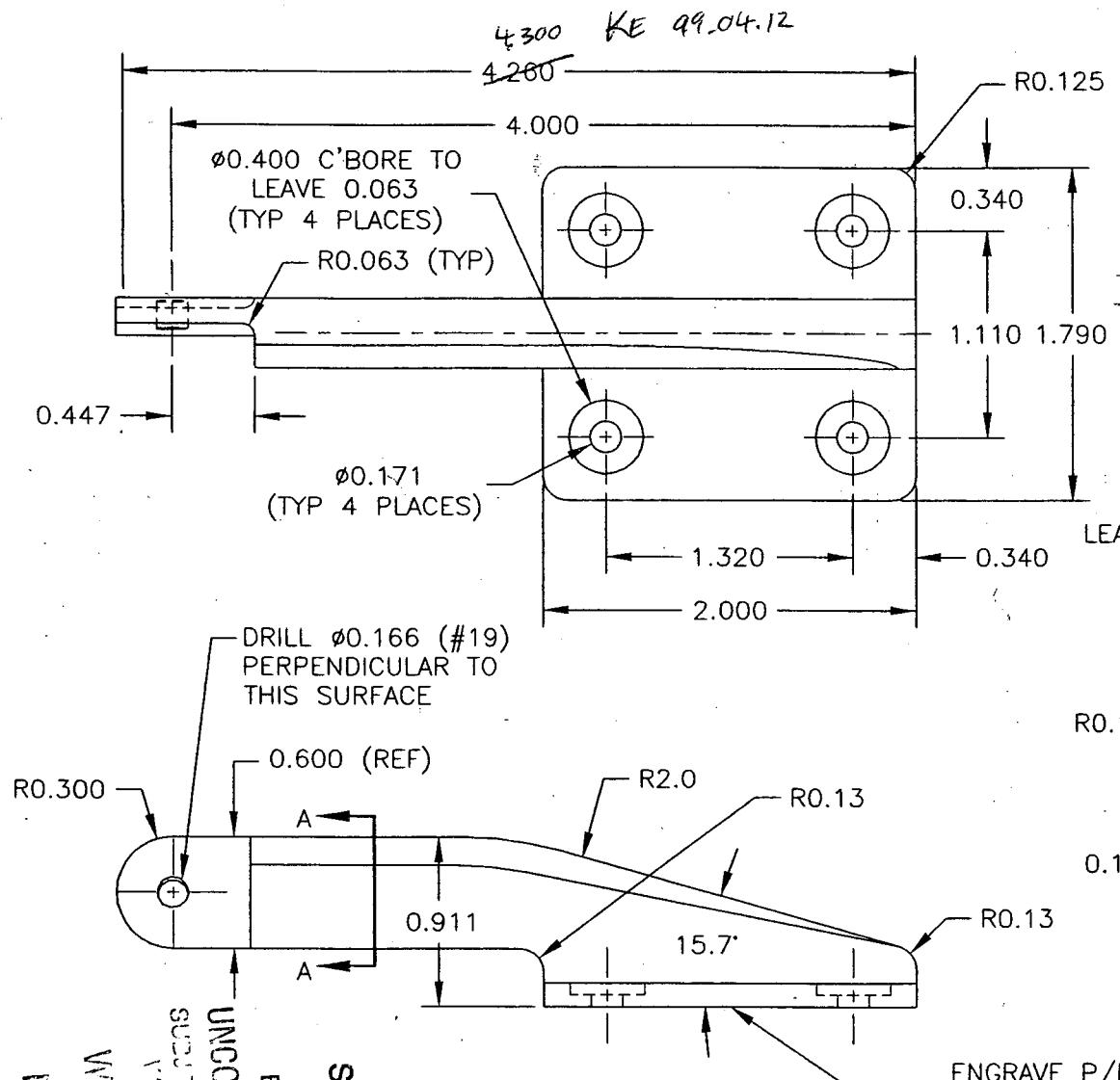
98.12.14

TITLE

HINGE BRACKET

**SECTION A-A**

ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)



D2857-1 SHOWN
D2857-2 OPPOSITE

IMPERIAL 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. 20101

Job Costing Report

Dart Aerospace Ltd.
HawkesburyApr 12, 2004
03:42 pm

Work Order No : 0020701
 Project Name : D2857-2
 Project For : WK420
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2857-2
 Description : Hinge Bracket
 Manufactured : Yes
 Amount Req'd : 24
 Amount Done : 0
 Start Date : 04-12-04
 Est Finish Date : 05-12-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

BANT AEROSPACE LTD

Work Order:

20700

Description:

Wing bracket

Part Number:

D857-2

Inspection Dwg:

Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	± 0.010	4.306	✓			
.340	"	.340	✓			
1.718	± 0.005	1.709	✓			
1.790	± 0.010	1.793	✓			
1.320	± 0.005	1.319	✓			
2.000	± 0.010	2.004	✓			
0.171	± 0.000	.171	✓			
<hr/>						
.147	± 0.010	.144	✓			
.376	"	.374	✓			
.126	"	.128	✓			
.611	"	.611	✓			
.063	"	.063	✓			
<hr/>						
.166	± 0.005	.166	✓			
.911	± 0.010	.907	✓			
.600	"	.606	✓			
<hr/>						
.125	± 0.010	.122	✓			
.150	"	.146	✓			
<hr/>						

Measured by:

S/104/30

Audited by:

E

Prototype Approval:

N/A

Date:

04.05.03

Date:

Rev:

Date:

Change:

New issue

Revised by:

Approved:

KJ/RF